

Work Order ID 115509

115509

Page 1

April-02-14 11:15:13 AM

Item ID: D3391-025

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Tube Assembly

Start Date: 4/02/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-04-02 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3391	I
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100

100

Mori Seiki

Mori Seiki CNC Lathe Large

MORI SEIKI CNC LATHE LARGE

0.00

Memo

0.00

Turn as per Folio FA599 Rev: AA & Dwg D3391 Rev: H

****REMOVE STEADY REST AND MACHINIG MARKS****

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

112

112

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

14-04-03
mm Lmm L
14/04/06Sh
14/4/23

April-02-14 11:15:13 AM

Page 2

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

Work Order ID 115509

April-02-14 11:15:13 AM

115509

Page 3

Item ID: D3391-025 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: Aft Tube Assembly Stop *NS2*

Start Date: 4/02/14 Start Qty: 1.00 *1*

Required Date: 4/16/14 Req'd Qty: 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								
160		0.00							
160	BENDING MACHINE - SKIDTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Form as per Dwg D3391 Using Bend Prog 3391025								
170		0.00							
170	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

H-4.3

DAS
03
9-88

DP 14-4-29

April-02-14 11:15:13 AM

Page 4

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Aft Tube Assembly

Stop *NS2*

Start Date: 4/02/14 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 4/16/14 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

180

0.00

180

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig .

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.297" and c'bore as per dwg D3391

6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3291.

7-Deburr

8- Scribe batch # on fwd end

Work Order ID 115509

April-02-14 11:15:13 AM

115509

Page 7

Item ID: D3391-025 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Tube Assembly
 Start Date: 4/02/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 4/16/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
235	Pressure Wash per QSI005 4.3	0.00							
235	HandFinish	0.00				1		76/145-26	
Hand Finishing	Memo AND REALODINE AS PER PAR09-043								
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
240	Powdercoat	0.00				1		14-716.	
Powder Coating	Memo START TIME: 2:40 OVEN TEMPERATURE: 320° FINISH TIME: 3:10							Pho →	
250	QC3- Inspect Part Finish	0.00							
250	QC	0.00				1		10/07/18	
Quality Control	Memo								

DAS
34
9-89

DAS
15
9-89

DQA: SWA Date: 14/08/61QA Closed: SWA Date: 14/7/28

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>115509</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D3391-025</u>		Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input checked="" type="checkbox"/>
NCR No. <u>14-4072</u>					Handing <input type="checkbox"/>

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				Found that tube has large chip in part		Scrub entire tube. unable to perform touchup	AS 14-7-17		DAS 16 9-89
Doc/Data						Touch up aluminum Requiri as per Q52005	N/A AS 14-7-17	14/07/18	
Equip/Tooling						Re Powder coat as per Q52005		(X1)	Q52042
Handling/Pre						Start			14/07/17
Material						End			
Operator						Re Spray part as per Q52005	AS 14-7-17		
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes
<input type="checkbox"/> Turning Sequence	<input checked="" type="checkbox"/> Finish
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function
	<input type="checkbox"/> Folio/Program
	<input type="checkbox"/> Grain
	<input type="checkbox"/> Hardware
	<input type="checkbox"/> Inspection Incomplete/Unqualified
	<input type="checkbox"/> Instructions Incomplete/Unclear
	<input type="checkbox"/> Misaligned/off center
	<input type="checkbox"/> Mislabeled
	<input type="checkbox"/> Misread
	<input type="checkbox"/> Off-set
	<input type="checkbox"/> Out of Calibration
	<input type="checkbox"/> Out of Sequence
	<input type="checkbox"/> Outside Dimensions
	<input type="checkbox"/> Over/Under tolerance
	<input type="checkbox"/> Part Incorrect
	<input type="checkbox"/> Part Lost/Missing
	<input type="checkbox"/> Part Moved
	<input type="checkbox"/> Positioned Wrong
	<input type="checkbox"/> Power Loss/Surge
	<input type="checkbox"/> Pressure/Forced
	<input type="checkbox"/> Set-up
	<input type="checkbox"/> Temperature/Cure
	<input type="checkbox"/> Weld
	<input type="checkbox"/> Wrong Stock Pulled
	<input type="checkbox"/> Other

Work Order ID 115509

April-02-14 11:15:13 AM

115509

Page 8

Item ID: D3391-025

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Tube Assembly

Start Date: 4/02/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260		0.00							
260	HandFinishing					1x	f	ell	u/c 1/18
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per Dwg D3391								
	2-Install Aft Cap as per Dwg D3391								
	A/ R Sikaflex-241/-291 1A124457								
	Sikaflex expiry date: 14/11								
	3- INSTALL WEARPLATES AS PER DWG								
270	QC5- Inspect part completeness to step on W/O	0.00							
270									
QC	Memo	0.00							
Quality Control									
280	Identify as per dwg & Stock Location: u/c	0.00							
280									
Packaging	Memo	0.00				1x	d	ell	u/c 1/20
Packaging									

1 15509

Page 9

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date:	4/02/14	Start Qty:	1.00	*1*
Required Date:	4/16/14	Req'd Qty:	1.00	*1*

Cust Item ID:

Customer:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop *NR2*

Insp. Stamp

0.00

290

QC:

Memo

0.00

Quality Control

14/7/22
mf
14-7-21

Picklist Print

April-02-14 11:15:15 AM

Page 1

Work Order ID: 115509

115509

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4095-047		Manufactured	No			260	Each	18.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D4095-047

Wearpad Assembly

**

all 11/07/18

Location	Loc Qty	Loc Code
FP001	18	
102241	2	
108289	16	

D4095-049		Manufactured	No			260	Each	13.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D4095-049

Wearpad Assembly

**

all 11/07/18

Location	Loc Qty	Loc Code
FP001	12	
109670	12	
FP002	1	
102216	1	

D6014-090		Manufactured	No			100	Each	69.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D6014-090

ALUMINUM EXTRUSION

**

Location	Loc Qty	Loc Code
LG003	69	
79742	17	
86063	52	

1 mm. L 14/04/02

Picklist Print

April-02-14 11:15:16 AM

Page 2

Work Order ID: 115509

115509

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

300.0000

4

4

D3670-4-200

Bushing

**

OK 14/05/05

Location

Loc Qty

Loc Code

FG

10

87709

10

LG001

290

103880

39

109108

242

96240

9

D2646

Manufactured No

270

Each

75.0000

1

1

D2646

Aft Cap

**

OK 14/07/10

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

71

103306

14

107857

1

110816

18

113830

38

April-02-14 11:15:16 AM

Shop Packet Print

Page 2

Picklist Print

April-02-14 11:15:16 AM

Page 3

Work Order ID: 115509

115509

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270

Each

1,420.000

2

2

D3672-1

ml 11/07/18

Phenolic Washer

Location

Loc Qty

Loc Code

FG

10

85222

10

ST060

1410

103845

4

112218

500

113581

500

93886

224

99099

182

x2

ALS4-1032-130

AEALS4-1032-130 Purchased

No

260

Each

9,937.000

14

14

ALS4-1032-130

ml 11/07/18

Rivnut

Location

Loc Qty

Loc Code

FP001

9832

M128649

9832

x14

ST279

48

M128211

48

st510

57

M126109

57

April-02-14 11:15:16 AM

Shop Packet Print

Page 3

Picklist Print

April-02-14 11:15:16 AM

Page 4

Work Order ID: 115509

115509

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

AELS8-1032-225

Purchased

No

270

Each

1,490.000

8

8

AI S4-1032-225

Rivnut

X?

**

14/03/14

Location

Loc Qty

Loc Code

FG

30

M127028

30

FP001

1000

M128649

1000

ST280

426

M127028

10

M128179

416

st555

34

M127092

34

X 0

AN3C4A

Purchased

No

270

Each

2,208.000

6

6

AN3C4A

Bolt

**

14/03/14

Location

Loc Qty

Loc Code

FG

20

122814

20

ST350/513

1000

M128606

1000

ST512

3

124221

3

ST513

1185

125388

122

M127410

1

M127832

62

M128634

1000

M128879

X 6

April-02-14 11:15:16 AM

Shop Packet Print

Page 4

Picklist Print

April-02-14 11:15:16 AM

Page 5

Work Order ID: 115509

115509

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No

270 Each 705.0000 4 4

AN3C5A

Bolt

ll 4/07/18

Location

Loc Qty

Loc Code

FG

5

M128811

x4

122800

5

ST350

700

M128057

700

NAS1149C0332R Purchased No

270 Each 9,644.000 10 10

NAS1149C0332R

WASHER

ll 4/07/18

Location

Loc Qty

Loc Code

GA

1005

M129499

x10

125654

1005

ST292

4968

m128591

4968

st510

3671

m126319

61

m127306

2500

m127410

1084

m127831

26

April-02-14 11:15:16 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

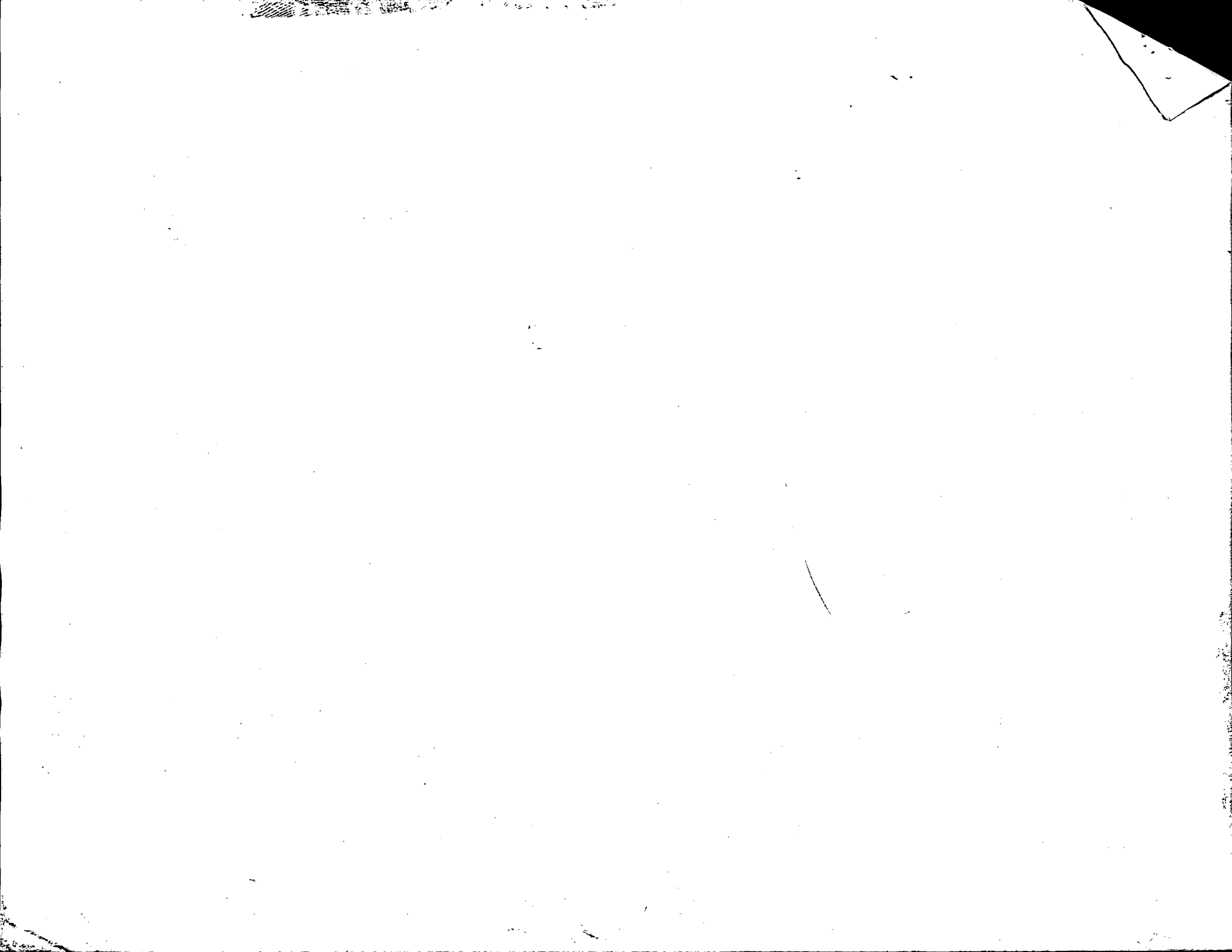
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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DART AEROSPACE LTD		Work Order:	115509
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391 Rev: I		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.00	✓		type	L6-25
3.500	+/-0.010	3.501	✓		vern	
Ø3.200	+/-0.010	3.199	✓		↓	
Ø3.750	+/-0.010	3.750	✓			
30° x 0.060 chamfer	+/-0.010	30° x .060	✓			
88.93	+/-0.030	88.93	✓		type	L6-25

Measured by: <i>mmL</i>	Date: 14/04/06
Audited by: <i>SmB</i>	Date: 14/4/23

HAAS Section						
1.526	+0.000/-0.030	1.500	✓		Vern	ML-06
7.500	+/-0.010	7.500	✓		"	
27.750	+/-0.010	27.750	✓		M-type	ML-08
31.750	+/-0.010	31.750	✓		"	
35.250	+/-0.010	35.250	✓		"	
3.300	+/-0.010	3.305	✓		Vern	ML-06
0.200	+/-0.010	.200	✓		"	
3.520	+/-0.010	3.523	✓		"	
0.687	+0.010/-0.000	.690	✓		"	
R0.062	+/-0.010	R.062	✓		R-L	
Ø0.484	+0.005/-0.001	Ø.485	✓		Vern	ML-06

Measured by: <i>mmL</i>	Date: 14/04/28
Audited by: <i>FK</i>	Date: 14/04/28

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	
L	12.11.28	88.93 dimension added	KJ	



